

Work Order ID 82652***82652***

Page 1

April-04-12 10:24:12 AM

Item ID: D3289-041
Revision ID:
Item Name: Float Web (206A/B)

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Start Date: 04/04/2012 Start Qty: 3.00
Required Date: 18/04/2012 Req'd Qty: 3.00

3

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/04 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3289	Rev D

100	Skidtubes	0.00
100		
Skidtubes	Memo	0.00
Skidtubes	1-Cut D2600-5-108 to as per Dwg D3289	
	2-Transfer drill web from D3283-3 doublers	
	3-Drill web using DT 8748 as per Dwg D3289	
	4-Using uni-bit, open holes as per Dwg D3289	
	5-Deburr holes and ends	

110	QC5- Inspect part completeness to step on W/O	0.00
110		
QC	Memo	0.00
Quality Control		

(3) CF 12-4-5

DP 12-4-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82652

82652

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April-04-12 10:24:12 AM

Item ID: D3289-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Web (206A/B)
 Start Date: 04/04/2012 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 18/04/2012 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.00							CF 12-4-5
Hand Finishing									
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00							DP 12-4-5
Quality Control									
140	Skidtubes	0.00							
140									
Skidtubes	Memo	0.00							CF 12-4-9
Skidtubes	1- Apply LPS between doublers and web as per dwg D32892- Coat rivets with LPS3- Rivet doublers as per dwg D3289A/R LPS-3 Batch: _____								No LPS-3 9/11.04.05

P10

W/O: 82652		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3289-041 PAR #: _____ Fault Category: skid tubes NCR: Yes No DQA: not Date: 12/04/14
 Resolution: use as is Disposition: use as is QA: N/C Closed: OK Date: 12/4/16

NCR: 121336		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-4-9	140	One rivet hole damaged	<u>CF</u> <u>12-4-9</u>	oversize hole to 0.158" and install MS20470AD45-7 B* <u>11/4/98</u> edge distance acceptable	<u>CF</u> <u>12-4-9</u>	<u>12-4-9</u>	<u>CF</u> <u>12-4-9</u>	<u>12-4-9</u>

NOTE: Date & initial all entries

Work Order ID 82652

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April-04-12 10:24:12 AM

Item ID: D3289-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Web (206A/B)
 Start Date: 04/04/2012 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 18/04/2012 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

NP 12-4-9
as per TO **(3)**

CF 12-4-5

12/4/10 *[Signature]*

12-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 10:24:21 AM

Page 1

Work Order ID: 82652

82652

Parent Item: D3289-041

D3289-041

Parent Item Name: Float Web (206A/B)

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:A04.09.28New IssueKJ/JLM

IPP Rev:B 07-09-09 As per Rev C JLM Verified By:EC

IPP Rev:C 07-12-06 as per Rev D DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS20470AD4-7

Purchased

No

100

Each

1,151.000

85

255

MS20470AD4-7

Rivet, Universal Head

**

255

CF 12-4-9

Location

Loc Qty

Loc Code

ST319

877

120769

877

ST320

274

116081

117

117887

9

118614

148

D2600-5-108

Manufactured

No

140

Each

159.0000

1

3

D2600-5-108

Extrusion 'I Beam' thin

**

3

CF 12-4-4

Location

Loc Qty

Loc Code

LG

159

47814

20

73909

139

D3283-3

Manufactured

No

140

Each

77.0000

2

6

D3283-3

Doubler

**

6

CF 12-4-4

Location

Loc Qty

Loc Code

LG

20

80356

20

Mezz

57

25879

16

26793

1

37371

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Ø0.500
(28 PLACES)

9.000

3.000 PITCH
(TYP)

30.000

3.000 PITCH
(TYP)

Ø0.625
(2 PLACES)

DRILL Ø0.128 HOLES TO
ALIGN WITH D3283-3 DOUBLER
(85 PLACES) C

D3283-3 DOUBLER (2)
MS20470AD4-7 RIVET (85)
INSTALL WITH LPS-3

3.000 PITCH
(TYP)

96.1

84.41

75.63

DETAIL A

D3289-1
WEB

D 40.10

35.08

33.86

32.61

28.63

22.13

DETAIL A

2.67

0.00

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

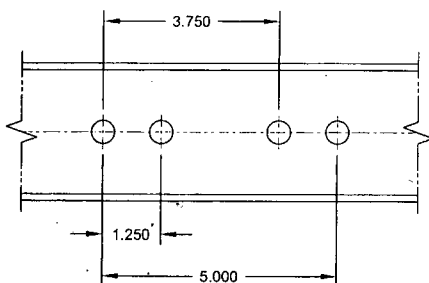
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 82652415
12/04/09

RELEASED
07.11.13



DETAIL A
(RIVET HOLES NOT SHOWN)
SCALE 1:5

D3289-041 FLOAT WEB

Qty	Part Number	Description
X	D3289-041	FLOAT WEB
1	D2600-5-108	EXTRUSION
2	D3283-3	DOUBLER
85	MS20470AD4-7	RIVET

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5-108 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-3 DOUBLERS AND D3289-1 WEB. INSTALL RIVETS COATED IN LPS LABORATORIES LPS-3
- 7) WEIGHT: 5.00 lbs

D	MID-FLOAT HOLES ON D3288 WERE MOVED 2.00" FWD & ROTATED INBOARD & OUTBOARD BY 17° DUE TO GHW INTERFERENCE. THEREFORE, 40.10 WAS 38.10.	MB	07.09.14
C	CORRECTED TYPO (-3 WAS -1)	MB	07.08.04
B	ADD HOLES FOR OEM COMPATIBILITY.	CP	05.03.16
A	NEW ISSUE	CP	04.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>qp</i>		
DRAWN	<i>qp</i>		
CHECKED	<i>qp</i>		
MFG. APPR.	<i>qp</i>		
APPROVED	<i>qp</i>		
DE APPR.	<i>qp</i>		
DATE	07.09.14		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3289 REV. D SHEET 1 OF 1 TITLE FLOAT WEB, 206A/B SCALE 1:10 COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries